

Date: Monday, 12/01/2009 2:29:01 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ADJUSTABLE ENGINE MOUNT KIT (205)
Job Number :	44545		
Estimate Number :	10548		
P.O. Number :		Part Number :	D205708011
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B80701 REV C
First Issue :	/ /	Project Number :	N/A
Previous Run :	37151	Drawing Revision :	C
	Type :	Material :	
	PURCHASED PARTS	Due Date :	23/01/2009
Written By :		Qty:	4
Checked & Approved By :	JLD 09.01.12	Um:	Each
Comment :	Est C 06.01.31 Added MS206136C12 JLM/AP Est Rev:D 07-12-12 as per ECN 1074 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



for JLD 09/02/06

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

09/02/06

2.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: *7968* for:

6	D3284-001 ✓	(B80702-1)	Sleeve ①
2	D3284-003 ✓	(B80703-1)	Stud ②
4	D3284-005 ✓	(B80704-1)	Stud ③
6	D3284-007 ✓	(B80705-1)	Stud ④
6	NAS509-12 -	Nut ⑤	
6	NAS509L12 -	NutStud ⑥	

To be assembled as per Dwg B80701 Rev. C

Possible Supplier: Northern Aero

Certificate of Conformity is required

09/01/14 ④ ass

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure Certificate of Conformity is attached

SS 09/01/21 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:29:01 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 44545

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect assembly. Visually inspect thread, fit and cad plating

S 02/01/22 x4 sets

5.0

D3284001

①

Sleeve



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-001 Sleeve B44545

ASSY 02/01/22 x4

6.0

D3284003

②

Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Stud

Pick:

Packing Kit (Note: (1) D205-708-011 Kit includes all parts listed below)

Qty Part Number Description Batch

2 D3284-003 Stud B44545

ASSY 02/01/22 x4

7.0

D3284005

③

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Stud

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty Part Number Description Batch

4 D3284-005 Stud B44545

ASSY 02/01/22 x4

8.0

D3284007

④

Stud



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Stud

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-007 Stud B44545

ASSY 02/01/22 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 44545

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D3284009

Bearing



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bearing

Pick:

Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-009 Bearing

B43617 x4

B41935 x2

B44781 16x/09/26

SS 09/01/22 (x4)

10.0

D3284011

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bearing

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty Part Number Description Batch

1 D3284-011 Bearing

B35625

SS 09/01/22 (x4)

11.0

MS206136C16

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty Part Number Description Batch

8 MS20613-6C16Rivet

19513

SS 09/01/22 (x4)

12.0

MS206136C18

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty Part Number Description Batch

4 MS20613-6C18 Rivet

M19513

SS 09/01/22 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 44545

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS206136C19

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D205-708-011

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
12	MS20613-6C19	Rivet	M106375 x6. M102296 x42.

JS 09/01/22

14.0

NAS50912

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
6	NAS509-12	Nut	B44545

Assy

JS 09/01/22

15.0

NAS509L12

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
6	NAS509L12	Nut	B44545

Assy

JS 09/01/22

16.0

MS206136C12

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
2	MS206136C12	Rivet	M105433

JS 09/01/22

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 09/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ADJUSTABLE ENGINE MOUNT KIT (205)

Job Number: 44545

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



(4x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-708-011

Location: 21

PPP Rev: A

9/2/06

SO

19.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/09 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

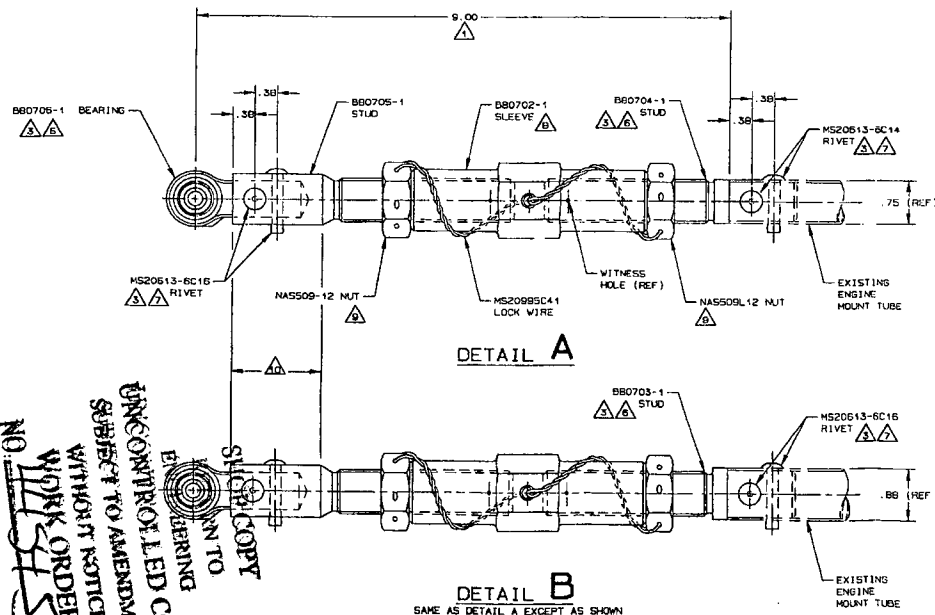
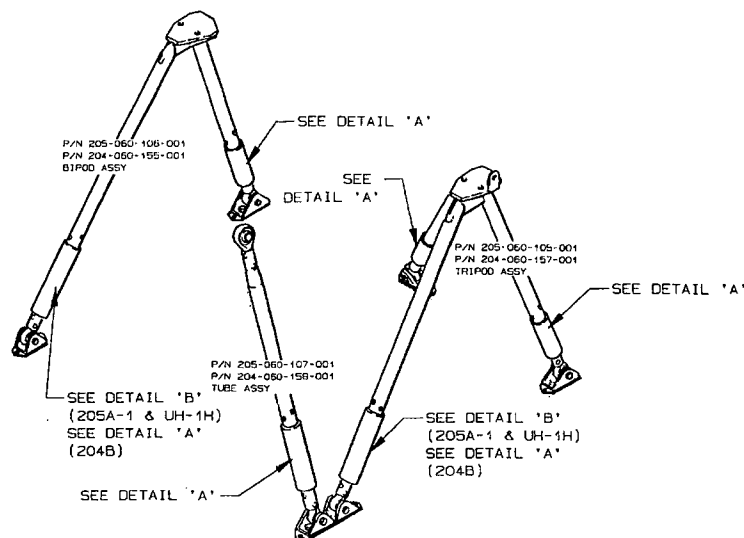
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NOTES:

- 1 CUT EXISTING ENGINE MOUNT TUBE AT DIMENSION SHOWN.
- 2 DEBURR OUTSIDE DIAMETER OF TUBE .005/.010 AND CHAMFER INSIDE DIAMETER .015/.025.
- 3 BOTTOM OUT BEARING IN B80705 STUD AND B80704 STUD IN TUBE. POSITION RIVET HOLES AS SHOWN AND LINE DRILL PARTS .194 DIA (#10 DRILL).
- 4 DISASSEMBLE PARTS AND DEBURR.
- 5 ZINC CHROMATE PRIME TUBE ASSY ALL OVER USING 77-P-1757, COLOUR GREEN.
- 6 RE-ASSEMBLE PARTS WET WITH HYSOL ADHESIVE EA934.
- 7 INSTALL RIVETS WET WITH HYSOL ADHESIVE EA934.
- 8 FILL SLEEVE WITH CORROSION PREVENTIVE COMPOUND MIL-C-16173 SUFFICIENT TO CAUSE SQUEEZE OUT, THEN ASSEMBLE THREADED PARTS AS SHOWN.
- 9 FOR AIRCRAFT INSTALLATION, BACK OFF NUTS AND ORIENT BEARINGS TO SUIT ENGINE DECK FITTINGS. ADJUST LENGTHS OF INDIVIDUAL TUBES WITH SLEEVE TO OBTAIN CORRECT ENGINE/TRANSMISSION ALIGNMENT PER BELL MAINTENANCE MANUAL. MAKE SURE STUDS ARE STILL VISIBLE THROUGH WITNESS HOLES. TORQUE NUTS 400 TO 600 IN-LBS AND LOCKWIRE AS SHOWN. SEAL LOCKWIRE HOLES IN SLEEVE AND AROUND NUT/THREAD INTERFACE WITH SEALANT PER MIL-S-8802.
- 10 ZINC CHROMATE WHERE INDICATED USING 77-P-1757, COLOUR GREEN.



NO. 111518
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WITHOUT NOTICE
WORK ORDER

NOTICE

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Record of Revisions

REV.	Date	Description of changes	by	approved
N/C	08 JAN 99	INITIAL RELEASE	TM	TIM MARTIN
A	10 MAY 99	REV. NATL LIST, ADD B80706-1 BRG.	SW	TIM MARTIN
B	01 FEB 00	CON B80701A1 INCORPORATED	TM	TIM MARTIN
C	09 OCT 03	CON B80701B1 INCPD	TM	TM

RELEASED FOR
USE BY
001 14 2003
AERO CONSULTING SERVICES LTD.

AR	AR	EA934	ADHESIVE	DEXTER/HYSOL
6	6	B80706-1	BEARING	ACS
AR	AR		SEALANT	MIL-S-8802, CLASS B
AR	AR		CORROSION PREVENTIVE COMPOUND	MIL-C-16173, GRADE 1
AR	AR	MS2099SC41	LOCK WIRE	
12	8	MS20613-BC14	RIVET	
12	16	MS20613-BC16	RIVET	
6	6	NASS509L12	NUT	
6	6	NASS509-12	NUT	
6	6	B80705-1	STUD	
6	4	B80704-1	STUD	
2	2	B80703-1	STUD	
6	6	B80702-1	SLEEVE	
1	1	-3	INSTALLATION	
1	1	-1	INSTALLATION	
-3	-1	PART NO.	DESCRIPTION	MATERIAL

QUANTITY PER UNLESS OTHERWISE SPECIFIED	UNLESS OTHERWISE SPECIFIED
dimensions are in inches	dimensions are in inches
Tolerances on:	Tolerances on:
Decimals	Decimals
Angles	Angles
.XXX ±.010	.XXX ±.010
.XX ±.03	.XX ±.03
.X ±.1	.X ±.1
USED ON	USED ON
090 9126 D	090 9126 D

APPROVALS	DATE	LIST OF MATERIALS
DRAWN: T MARTIN	27 JAN 98	NORTHERN AERO INDUSTRIES 1845 ST. MATTHEWS AVENUE WINNIPEG, MANITOBA R3H 0A8
CHECKED:		INSTALLATION - ENGINE MOUNT, ADJUSTABLE, BELL 204/205
PROJECT ENGINEER		CODE IDENT NO. 36929
STRESS:		REV. NO. B80701
AVIATION:		REV. C
		SCALE: FULL
		SHEET 1 OF 1

AERO CONSULTING SERVICES COMPUTER DRAWING SYSTEM

Northern Aero Industries Ltd

25 Dunlop Avenue
Winnipeg, Manitoba
R2X 2V2

Phone: (204) 772-9922

Fax: (204) 772-7568

**Packing List**

Sales Order: SO2063
Shipper No: 1
Ship Date: 19-Jan-09
Page: 1 of 1

SOLD TO

DART AEROSPACE LTD. - DART
1270 ABERDEEN STREET

HAWKESBURY ON K6A 1K7
CANADA

Order Date: 15-Jan-09

Purchase Order: 00007968

Reference: Shipment 1 for SO20634

SHIP TO

DART AEROSPACE LTD. - DART
1270 ABERDEEN STREET

HAWKESBURY ON K6A 1K7
CANADA

Attn: CHANTEL CLAVOIE

Phone: (613)632-9577

Fax: (613)632-1053

Ship Via:

Item ID	Description	Quantity	UM
B80702-1	SLEEVE	24	EA
	17 EA LOTNO 07-3006		
	7 EA LOTNO 08-1874		
B80703-1	7/8 STUD	8	EA
	8 EA LOTNO 07-2903		
B80704-1	3/4 STUD	16	EA
	13 EA LOTNO 07-2904		
	3 EA LOTNO 08-1927		
B80705-1	STUD	24	EA
	24 EA LOTNO 08-2459		
X NAS509-12	NUT (.7500-16 UNJF-3B)	24	EA
	1 EA LOTNO 07-2807		
	23 EA LOTNO 07-2750		
X NAS509-L12	NUT, STEEL (.7500-16 UNJF-3B-LH) LH TH	24	EA
	10 EA LOTNO 06-3290		
	14 EA LOTNO 08-1060		
ASSEMBLY		4	LOT
	LOT		

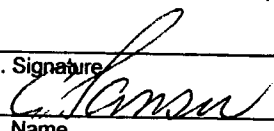
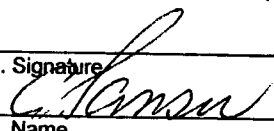
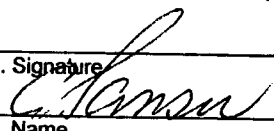
Returned items will be subject to a 25% re-stocking charge pending inspection of the returned goods for completeness and damage.

CERTIFICATE OF CONFORMANCE

"I hereby certify that the aircraft parts and / or materiel described hereon were acquired from a source of supply that is consistent with conditions under which DOT distributor approval No. 88-97 has been granted."

Signed:

Date: 20 JAN 09

1. Approving Civil Aviation Authority / Country TRANSPORT CANADA		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE		3. Form tracking No. SO20634-1	
4. Organization name and address NORTHERN AERO INDUSTRIES LTD. 25 Dunlop Avenue Winnipeg, Manitoba R2X 2V2 Canada				5. Work Order/Contract/Invoice PO 00007968	
6. Item	7. Description	8. Part No.	9. Qty.	10. Serial/Batch No.	11. Status/Work
1	SLEEVE	B80702-1	17	BATCH # 07-3006	New
2	SLEEVE	B80702-1	7	BATCH # 08-1874	New
3	7/8 STUD	B80703-1	8	BATCH # 07-2903	New
4	3/4 STUD	B80704-1	13	BATCH # 07-2904	New
5	3/4 STUD	B80704-1	3	BATCH # 08-1927	New
6	STUD	B80705-1	24	BATCH # 08-2459	New
12. Remarks These Aeronautical Products conform to approved data in accordance with TCCA STC Number SH99-11 and FAA STC Number SR00953NY and SR01395NY).					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			13b. Signature  13c. Approved Organization Number AMO-88-97 13d. Name Allen Sansom 13e. Date (dd mmm yyyy) 20-Jan-08		
14a. Authorized Signature  14b. Approved Organization Number AMO-88-97 14c. Name Allen Sansom 14d. Date (dd mmm yyyy) 20-Jan-08			14e. Authorized Signature  14f. Approved Organization Number AMO-88-97 14g. Name Allen Sansom 14h. Date (dd mmm yyyy) 20-Jan-08		
INSTALLER RESPONSIBILITIES					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in Block 1 specified. Statements in block 13a and 14a do not constitute installation certification. In all cases, the technical record with the applicable national regulations before the aircraft may be flown.			MUST ensure that their regulations recognize certifications from the country for the aircraft must contain an installation certification issued in accordance		